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RBWA353A04
Job Sheet 199196



Part No: RBWA353A04

Job Qty: 5 pcs

DAS
21
9-89

Part Name: Pmc Oil Filling Quick Disconnect



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/14/19

Job Tracking No:

Due Date: 9/13/19

Created By: Marie Lajeunesse

Type: Stock

Description: SIOP

Note: DWG RBWA353A04 Rev 4 IPP Rev A 18.02.13 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	6 pcs	9/13/19		0.00	6.00	Small Fab - 1		MLL
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
							Small Fab - 8		
120	QC 5	6 pcs	9/13/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
130	Packaging 3-1 - Stock - B4B	6 pcs	9/13/19		0.00	0.00	QC 5 - 40		SEP 27 2019
							QC 5 - 61		
							QC 5 - 81		
							Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		



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Container No: S217957



Part: RBWA353A04

Job No: 199196

Serial No/Batch: S217957

Revision: 4

Inspector:

Exp Date:

Instructions:

Date: 09/27/19

DAS
40
9-89

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				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	DAS
				Packaging 3 - 8 - B4B	28
				Packaging 3 - 9 - B4B	9-89
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140	QC 21 - SA	6 pcs	9/13/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

Part Op 110 - Small Fab - 1-Assemble as per DWG. Sheet . 2-Engrave 1632T22 tag using marktronic engraver as per DWG. 3-Descriptions: Fabricate and attach lanyard as per DWG.

120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location: _____

140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
78 1632T22	Aluminum Tag 1" X 2" X 0.04"	5 6 pcs (1 ea)	110-Small Fab - 1	5200927
27 2619	Spring Rnd 3/4"	5 6 Ea (1 ea)	110-Small Fab - 1	5075045
26 3896T31	Ferule 1/16 X 3/8" - Aluminum	10 12 Ea (2 ea)	110-Small Fab - 1	5199293
44 50715K179	Female Pipe Adapter SS	5 6 Ea (1 ea)	110-Small Fab - 1	5206411 4x SA9332
52 91665A350	Retaining Ring, 7/16" Shaft	5 6 Ea (1 ea)	110-Small Fab - 1	5200936
47 9262K613	O-Ring 13mm OD x 1mm	5 6 Ea (1 ea)	110-Small Fab - 1	5046249
CL-2-C	Lanyard Wire	2.5200 ft (.42 ea)	110-Small Fab - 1	5190004
RBWA353A04-01	Cap	6 pcs (1 ea)	110-Small Fab - 1	5212295
RBWA353A04-02	Sleeve	6 pcs (1 ea)	110-Small Fab - 1	5214354
RBWA353A04-03	Barb	6 pcs (1 ea)	110-Small Fab - 1	5212109
137 RBWA353A04-05	Quill	6 pcs (1 ea)	110-Small Fab - 1	5213428
6 RBWA353A04-06	Cap	6 pcs (1 ea)	110-Small Fab - 1	5212090
93 RBWA353A04-07	Valve	6 pcs (1 ea)	110-Small Fab - 1	5214874
36 RBWA353A04-08	Screw (Modified B/O)	10 12 pcs (2 ea)	110-Small Fab - 1	5157801
S1030	Spring .025 Wire: .300 O.D X .5 free length	5 6 Ea (1 ea)	110-Small Fab - 1	

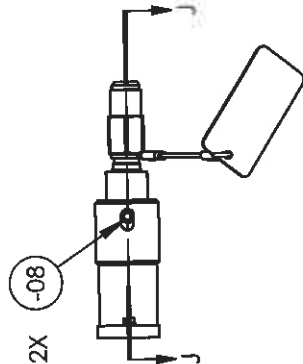
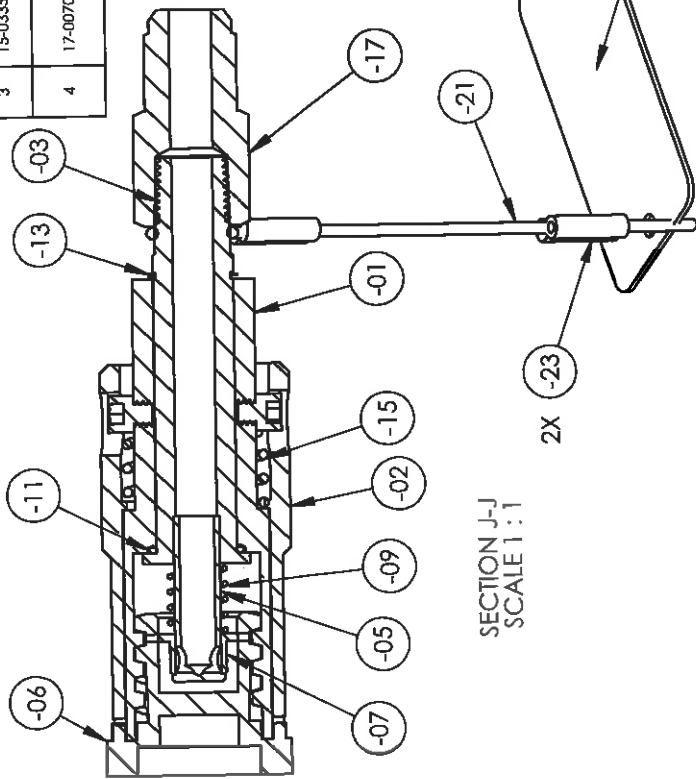
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	1632T22	6	153	0
	2619	6	25	0
	3896T31	12	704	0
	50715K179	6	10	0
	91665A350	6	29	0
	9262K613	6	78	0
	CL-2-C	3	1,168	0
	RBWA353A04-01	6	5	0
	RBWA353A04-02	6	5	0
	RBWA353A04-03	6	7	0
	RBWA353A04-05	6	6	0
	RBWA353A04-06	6	5	0
	RBWA353A04-07	6	6	0
	RBWA353A04-08	12	9	0
	S1030	6	10	0
Part Specifications				
Specifications could not be found.				

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REVISIONS

REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		REDESIGNED ASSEMBLY	2/22/2011	JAG	
2		DELETED -19, -21, & -23 CHD -15 FROM HOSE CLAMP. ADDED -19, -21, & -23 CHD TO CLEAR ANODIZE. -02 CHD TO CLEAR ANODIZE. CHD -03 THRU HOLE FROM Ø.17, CHD DESIGN ADDED 1/8 NPT -27 FOR FITTING. CHD -05 ID FROM Ø.14 & CHD LIMIT DIMENSION FROM Ø.2510-.2514 S.F. -07 CHD -07 TO LIMIT DIM. FROM Ø.2515-.2520 & S.F. -05 PER D.W.	1/17/2012	RJC	DW
2A		-03 REMOVED X.50 DEPTH FROM 1/8 NPT	1/31/2013	BIM	GE
3	15-0335	-01 DIM WAS Ø.675 IS Ø.665 TO ACCOMMODATE NEW .15 SPRING. -02 CHD DIM WAS 2X Ø.800 IS Ø.800. ADDED DIM Ø.810 FOR NEW SPRING. CHD ENGRAVE NOTE WAS ENGRAVED IN TO FIT IS ENGRAVE T/N. S/N. MADE IN USA. -15 CHD T/N WAS CENTURY SPRING #B15-66 IS 2619.	10/13/2015	RJC	JAG
4	17-0070	UPDATED TO NEW STANDARDS -01 CHD FLANK OF THREAD START WAS ON CENTERLINE, IS 5° OFFSET FROM CENTERLINE WAS 17° IS (1.01) IS (.081) WAS .101 IS .100. -03 CHD DIM WAS 2X Ø.800 IS Ø.800. -05 CHD DIM WAS Ø.2515/.2510 S.F. -07 IS Ø.2515/.2510 (S.F. -07). -06 ADDED. -07 CHD DIM WAS Ø.2530/.2520 S.F. -05 IS Ø.2530/.2520 (S.F. -05).	3/21/2017	SM	JAG



TITLE PMC OIL FILLING QUICK DISCONNECT

DWG NO. RBWA353A04 REV 4

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
 .XXX ± .005 FRACTIONS ± 1/8
 .XX ± .01 ANGLES ± .5°
 .X ± .1 SURFACES = 125/
 1. BREAK ALL SHARP EDGES
 .015 X 45° OR .015R
 2. DIMENSIONAL LIMITS APPLY AFTER PLATING
 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
 USED ON MODEL

DRAWN BY: GILBERT
 CHECKED: DD 03/22/2017
 APPR: AA 03/28/2017
 QA APPR: JL 03/29/2017
 APPROVED: JAG 04/03/2017
 SCALE 1:3 DATE 2/22/2011 AGUSTA HELICOPTERS SHEET 1 OF 8

B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	-01	1	CAP	6061	6-32 X 1/8 [MCMASTER-CARR #92196A139] MODIFIED	2
	-02	1	SLEEVE	6061	Ø.025 WIRE: Ø.300 OD X .5 FREE LENGTH (RIED #51030)	3
	-03	1	BARB	303/304 S.S.	Ø13mm OD X 1mm [MCMASTER-CARR #9262K613]	4
	-05	1	QUILL	303/304 S.S.	Ø7/16 SHAFT [MCMASTER-CARR #9166SA350]	5
	-06	1	CAP	6061	Ø.78 [CENTURY SPRING #2619]	6
	-07	1	VALVE	303/304 S.S.	MCMASTER-CARR #50715K179	7
	-08	2	SCREW	S.S.	1/32 X 1 X 2	8
B/O	-09	1	SPRING	MUSIC WIRE	[7X7 CABLE] Ø1/16 X 5in. [CARR LANE #CL-2-2]	1
B/O	-11	1	O-RING	BURNA-N	Ø1/16 X 3/8 [MCMASTER-CARR #3896731]	1
B/O	-13	1	EXTERNAL RETAINING RING	SPRING STEEL		1
B/O	-15	1	SPRING	SPRING STEEL		1
B/O	-17	1	FEMALE PIPE ADAPTER	S.S.		1
B/O	-19	1	TAG	ALUMINUM		1
B/O	-21	1	LANYARD	COATED GALV. STEEL		1
B/O	-23	2	FERRULE	ALUMINUM		1



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

DISPOSITION		DEPARTMENT/PROCESS			
Job: _____	Rework Scrap Use-as-is	Skid-tube Machining Large Fab	Cross tube Small Fab Finishing	Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging	Engineering Water Jet Supplier Quality
Date: _____	Sequence #: _____	MRB (QS1042)			
Description Work Order Deviation		Disposition			
		Completed By			
		Lead hand / Supervisor			
		QC / QA Coordinator			
Root Cause		FAULT CATEGORY			
Operator	Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong	
Manufacturing Process	Bending	Misaligned/off center	Folio/Program	Outside Tolerance	
Equip/Tooling	Crushing	BOM/Route	Grain Direction	Drawing	
Handling/Preservation	Cracks	Broken/Damage/Defect	Weld	Finish	
Material	Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing	
Product Improvement	Marks/Chatter	Drill Holes	Out of Sequence	Misread	
Process Improvement	Mislabeled	Fit/Function	Off-set/Set-up		
Human Factors	Other/Details:				